



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5770-041

Job Sheet 208150



Part No: D5770-041

Job Qty: 2 pcs

Part Name: Attachment Hoop



Part Weight: 0 lbs

Job Created: 3/12/20

Due Date: 3/24/20

Type: Stock

Status: ~~Released~~ DATE: ~~3/12/20~~ Priority: Medium

Job Tracking No:

Created By: Jennifer Renwick

Description:

Note: URF 20-522 DWG D5770 REV.A IPP REV:A NEW ISSUE 20.01.14 JV VERF:DD

Ship Via:

POSITIVE RECALL

EFFECTIVE 2/12/12 AUTH: SAK



Bill of Materials


Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Conventional Mill - 1	2	3/24/20	3/24/20	0.25	0.67	Conventional Mill - 1			1/1 20/3/13
		pcs					Conventional Mill - 2			
110	QC 2	2	3/24/20	3/24/20	0.00	0.00	QC 2 - 1			
		pcs					QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 66			
							QC 2 - 64			

ART

EROSPACE

Order No: S263547



5770 - 041

: 208150

No/Batch: S263547

REV.A

ns:

1270

Hawke

CANADA

TEL

Email

www

Date:



Container No: S263547



Part: D5770-041

Job No: 208150

Serial No/Batch: S263547

Revision: REV.A

Inspector:

Exp Date:

Instructions:

1270
Hawkesbury
CANADA
TEL:
Emil
ww

Date:

Print 3/12/20 5:55 AM Dart.Renwick.Jennifer

3/12/2020

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 89	
				QC 2 - 76	
				QC 2 - 86	
120	QC 8	2	3/24/20	0.00 0.00	
	pcs				
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130	Large Fab - Welded Assy-	2	3/24/20	0.00 1.00	
	1	pcs			
				Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B	
				(Various)	
				Large Fab - 12 - B4B	
140	QC 9	2	3/24/20	0.00 0.00	
		pcs			
				QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
150	QC 5	2	3/24/20	0.00 0.00	
		pcs			
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	

m/20/03/14

Sh

DAS
43
9-89

Plex 3/12/20 8:55 AM Dart, Renwick, Jennifer

				QC 5 - 24	
				QC 5 - 2	
				QC 5 - 43	DAS
				QC 5 - 49	43
				QC 5 - 51	9-28
				QC 5 - 56	
				QC 5 - 68	
				QC 5 - 8	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 81	
				QC 5 - 81	
160 Packaging 3-1 - Stock -	2	3/24/20	0.00 0.00	Packaging 3 - 1 - B4B	
B4B	pcs			Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	DAS
				Packaging 3 - 20 - B4B	43
				Packaging 3 - 21 - B4B	9-28
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
170 QC 21 - SA	2	3/24/20	0.00 0.00	QC 21 - SA - 21	MAR 19 2020
	pcs			QC 21 - SA - 70	QAS
				QC 21 - SA - 83	51

Part Op 100 - 1-Start with D5770-5 hoop as stock. 2-Machine as per drawing see sheet 3 detail C. 3-Debur

Description: 119 - QC2- Inspect parts off machine FAI/FAI

120 - QC8- Inspect parts - second check

130 - 1-Attach two D5770-7 lugs to 11.000" spacing jig DT. *NA Cd* using 3/8-24 bolt. Align lugs to slots in hoop prepared in step 1. Centre as per view A-A sheet 1. 2-Weld as per sheet 1. *1.45* 150 rod Batch: *139072*

140 - QC9- Inspect visual per QSI004- Fusion Welds

150 - QC5- Inspect part completeness to step on W/O

160 - Identify as per dwg & Stock Location: _____. See note 6.

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5770-5	Hoop	2 pcs (1 ea)	100-Conventional Mill - 1	S261807
D5770-7	Lug	4 pcs (2 ea)	130-Large Fab - Welded Assy-1	S259494

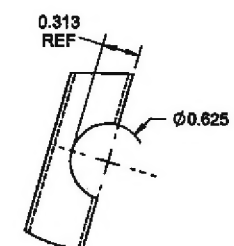
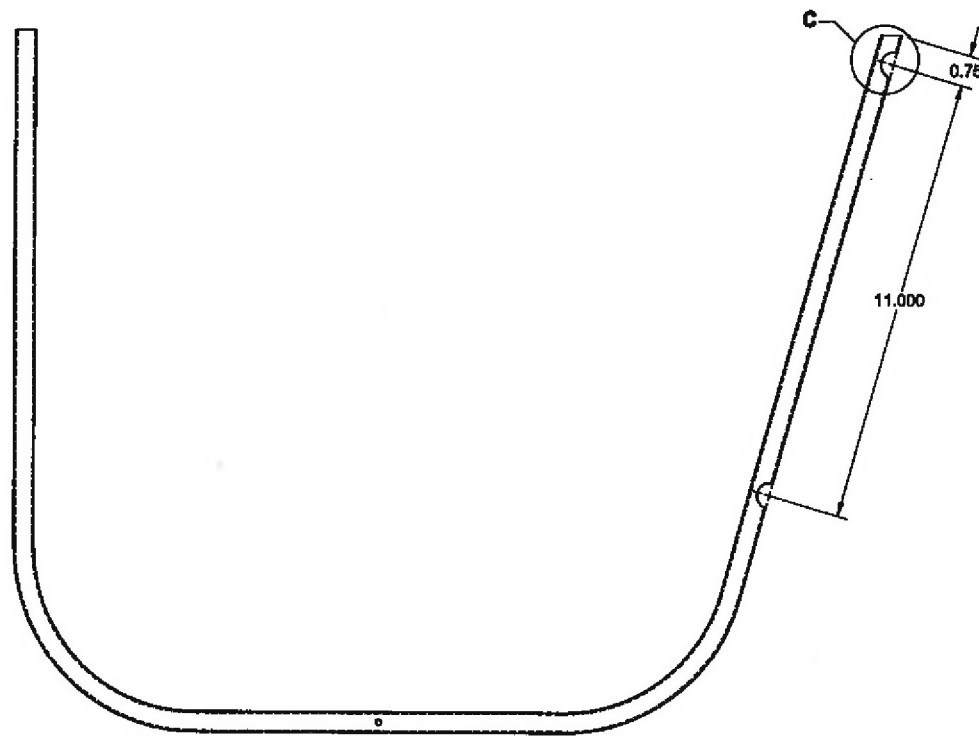
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Conventional Mill - 1	D5770-5	2	10	0
130-Large Fab - Welded Assy-1	D5770-7	4	12	0

Part Specifications

Specifications could not be found.

Plex 3/12/20 8:55 AM Dart.Renwick.Jennifer



DETAIL C
SCALE 3X, 2 PL

D5770-1 HOOP

- NOTES:**
- 1) MATERIAL: MAKE FROM D5770-5
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.84 lbs

RELEASED
2020 FEB 18 NO

APPROVED

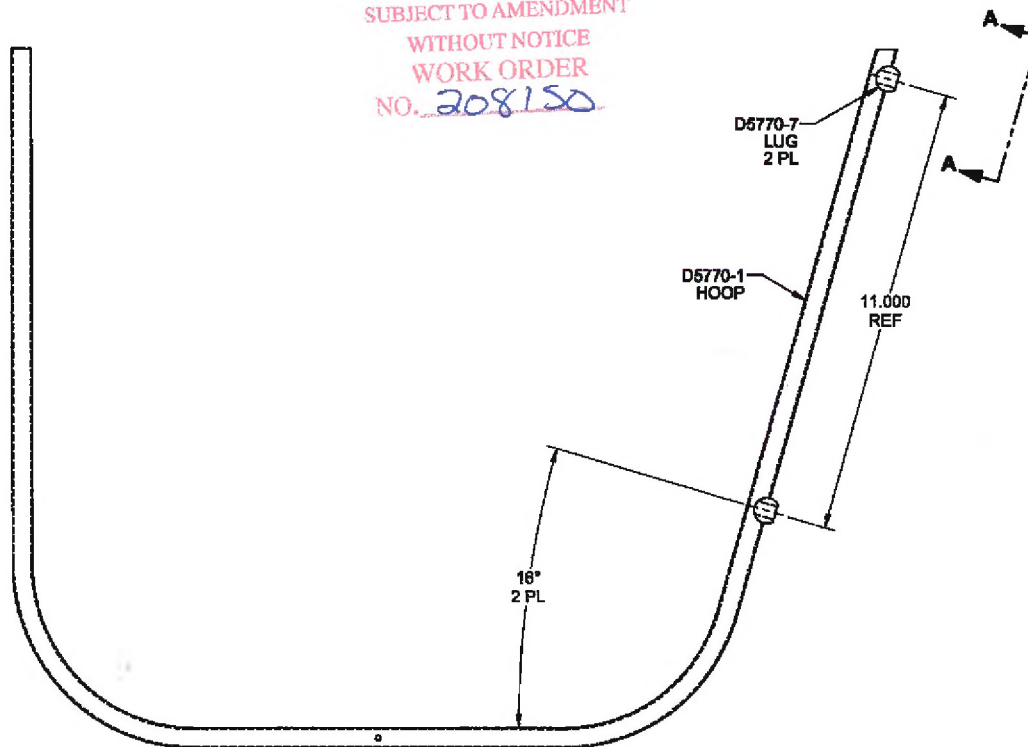
DESIGN	ZF
DRAWN	ZF
CHECKED	KPT
MFG. APPR.	DD
APPROVED	NO
DE APPR.	CP
DATE	20.01.09

UNDER REVIEW
URF 2020-522 20.02.14 (NO)

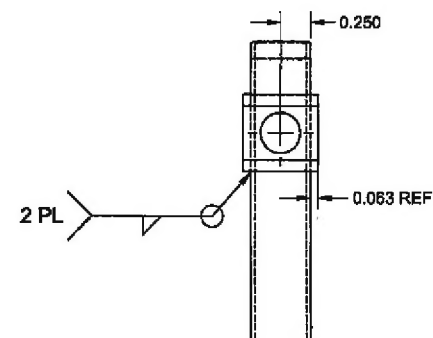
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D5770	REV. A
TITLE BASKET HOOPS	SHEET 3 OF 7
	SCALE NTS
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QTY -041	P/N	DESCRIPTION
X	D5770-041	ATTACHMENT HOOP
1	D5770-1	HOOP
2	D5770-7	LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 208150



D5770-041 ATTACHMENT HOOP
(DERIVED FROM AERO DESIGN P/N 76422-01)



VIEW A-A
SCALE 3X, 2 PL

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 - 7) WEIGHT: 0.91 lbs
 - 8) WELD PER DART QSI 004

RELEASED

2020 FEB 18 NO
ECN 2020-521

APPROVED

A NEW ISSUE		ZF	20.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	ZF		
DRAWN	ZF		
CHECKED	KPT		
MFG, APPR.	DD		
APPROVED	NO		
DE APPR.	CP		
DATE	20.01.09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D5770

TITLE

BASKET HOOPS

REV. A

SHEET 1 OF 7

SCALE

NTS

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INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause <div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
Other/Details:					